

Date: Friday, 16/05/2008 9:14:16 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : INSTALL D350-636-043

Job Number : 39191

Estimate Number : 10804

P.O. Number :

This Issue : 16/05/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 12/05/2008 Type : SKIDTUBES

Previous Run : 38847

Part Number : D350636013

Drawing Number : D350-636-013

Project Number :

Drawing Revision :

Material :

Due Date : 19/05/2008

Qty: 1 Um: Each

Written By : Checked & Approved By : 

Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile &amp; type labels per PPP CHG004

08.5.13

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D350-636-013 B

33392

3.0 D350636013 Skidtube LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Skidtube LH

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

INSTALL STAINLESS STEEL WEARPLATES  
PER DSI 9413 REV.A

JSL

5.0 D35371 Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

batch B33749

JSL

08.05.26 (X)

Date: Friday, 16/05/2008 9:14:16 AM  
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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INSTALL D350-636-043

Job Number: 39191

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D353525	Wearshoe
-----	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

batch B38162

JSJ

7.0	D353625	Gasket
-----	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

batch B38565

JSJ

8.0	D37941	Gasket
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B39279

JSJ

9.0	D37931	Wearshoe
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B39419

JSJ

10.0	D37911	Wearplate
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

B39276

JSJ

11.0	D37943	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B39361

JSJ

12.0	D37933	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B39278

JSJ

13.0	D36721	Phenolic Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Phenolic Washer

B34470

JSJ

08-05-2008 (10)

Date: Friday, 16/05/2008 9:14:16 AM  
User: Linda Lacelle

339191

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INSTALL D350-636-043

Job Number: 39191

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

M108062

MS

15.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

M108079

MS

08-05-26

(20)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT

ORIGINAL KIT WITH TUBE

808/05/26 (20)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/05/26 (20)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RE-PACKAGE PER PPP

USING NEW B/N - CHG005004

NEW LABELS REQ'D

Rev 9

8/5/30

SC

(1x)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/30

08/05/30

Job Completion



MS 08-05-26 (20)

Use following hardware for installation of wearplates:

PART NO:

AN3C-4A

M1521083-C8

AN960-C-10 L

AN3C-4A

QTY:

12

1

32

22

BATCH NO:

M107737

M107756

M107971

M108077

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

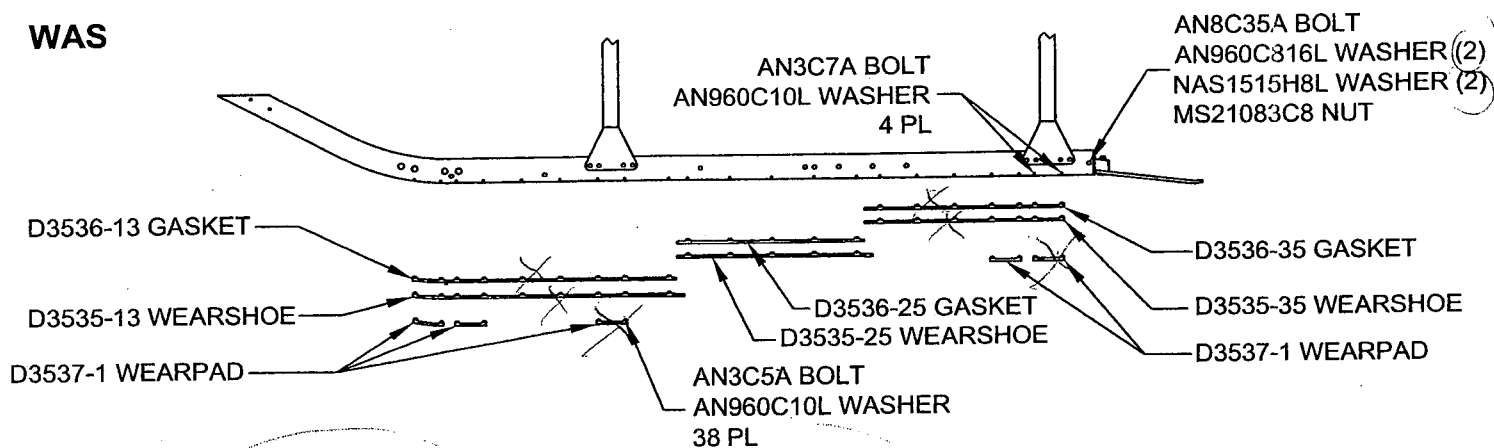
REF CANADIAN STC: SH99-7

FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004:

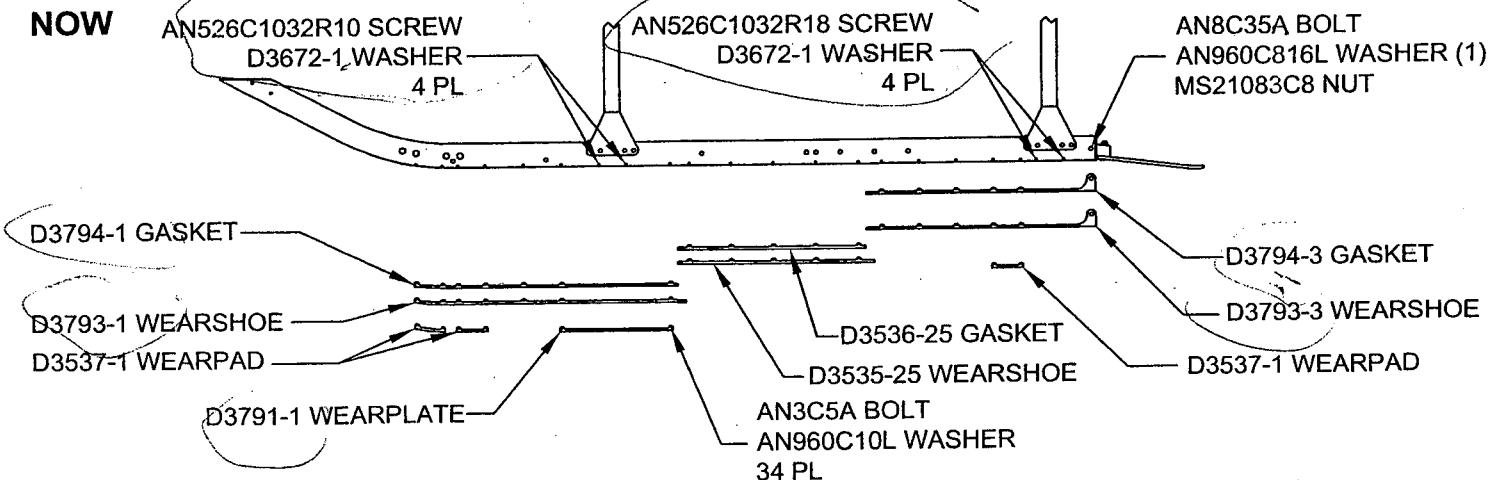
TO IMPROVE THE INSTALLATION OF THE DART D350-636-011/-012/-013/-014 SKIDTUBES ONTO THE CROSSTUBES, THE INSTALLATION AND PART NUMBERS OF THE FWD AND AFT WEARSHOES/GASKETS HAVE BEEN REVISED AS SHOWN IN FIGURE 1 BELOW.

FOR EXISTING CUSTOMERS THAT WOULD LIKE TO IMPROVE THE INSTALLATION OF THE SKIDTUBE TO THE CROSSTUBE, REFER TO PAGE 3 OF THIS DOCUMENT

**WAS**



**NOW**



**FIGURE 1 - D350-636-011/-012/-013/-014 AT CHG 004 AND INSTALLATION OF DSI 9413-011**  
(LOCATION OF AN526C1032RXX SCREWS ARE **NOT** TO BE USED TO MOUNT WEARSHOES)

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.		DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE INSTALLATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**PRELIMINARY ISSUE**

W/ 39191





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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 2 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS

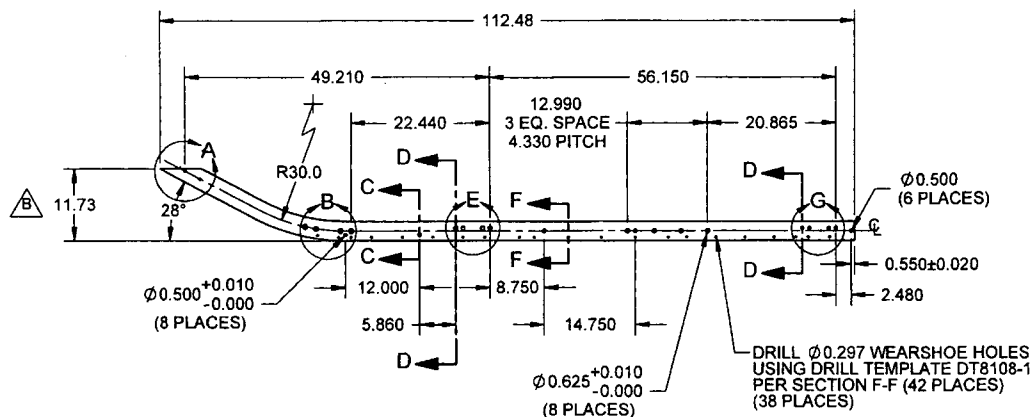
GENERAL NOTES:

**RELEASED**  
07-08-02 *[Signature]*

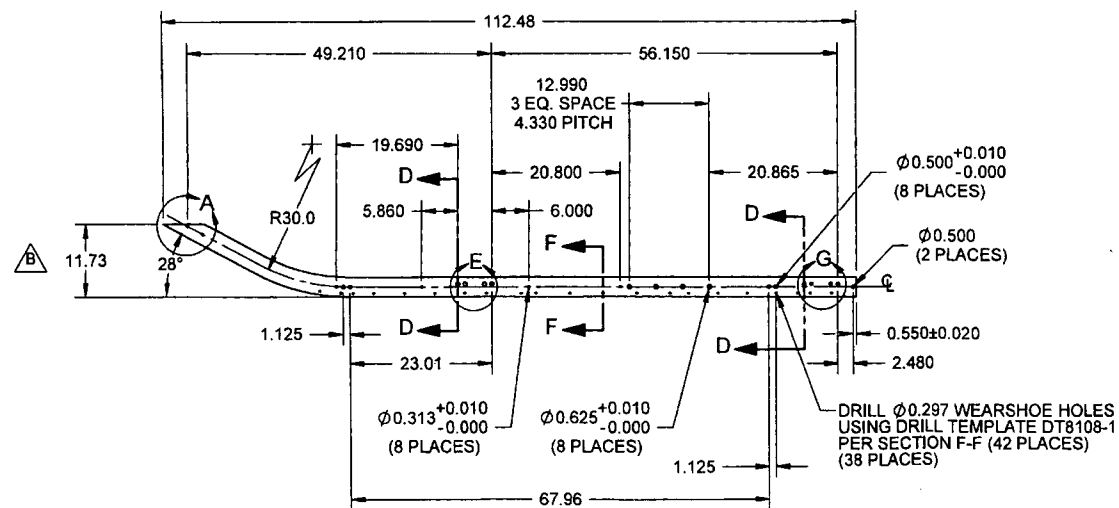
1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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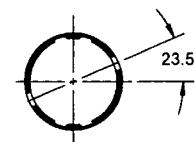
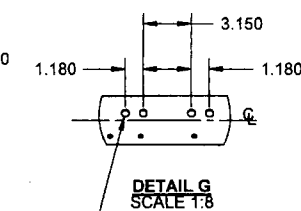
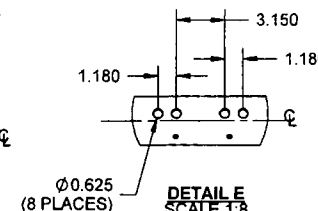
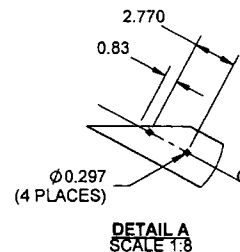
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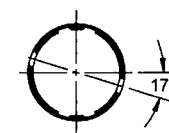
**D2750-1 LH SKIDTUBE (SHOWN)**  
**D2750-2 RH SKIDTUBE (OPPOSITE)**



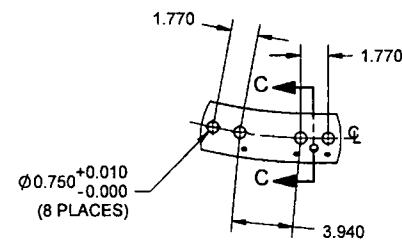
**D2750-3 LH SKIDTUBE (SHOWN)**  
**D2750-4 RH SKIDTUBE (OPPOSITE)**



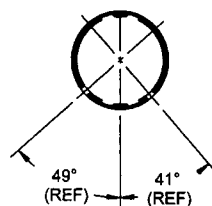
**SECTION C-C**  
**SCALE 1:4**



**SECTION D-D**  
**SCALE 1:4**




**DETAIL B**  
**SCALE 1:8**  
(ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)



**SECTION F-F**  
**SCALE 1:4**

**RELEASED**  
07-08-00

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CHECKED <b>PH</b>	APPROVED 	DRAWING NO. <b>D2750</b>	REV. E SHEET 3 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE 1:20
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INSTALL ALS4-1032-225  
INSERTS (4 PLACES)  
AFTER FINISH

D2750-1 (LH) OR  
D2750-2 (RH)

INSTALL ALS4-1032-225  
WEARSHOE INSERTS (38 PLACES)  
AFTER FINISH

**D2750-041 ASSEMBLY (SHOWN)  
D2750-042 ASSEMBLY (OPPOSITE)**

BLACK ANTI-SKID

BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

2.0  
(TYP)

1.78 (REF)  
(TO D2739 WEB)

D3488-041  
(OR D3488-042)

NO INSERT

WELDED SPACER  
NOT REQUIRED

D3535-35  
D3536-35

AN3C7A BOLT (REF)

D3537-1

**RELEASED**  
07.05.17

D2744 CAP

**DETAIL H**  
SCALE 1:5

INSTALL:  
AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

**SECTION J-J**  
SCALE 1:5

INSTALL AT AFTMOST  
D3537-1 WEARPAD:  
AN3C7A BOLTS (1)  
AN960C10L WASHER (1)  
(4 PLACES)

INSTALL:  
AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
(38 PLACES)

**SECTION N-N**  
SCALE 1:5

D2743 SPACER (REF)  
(TYP)

**SECTION M-M**  
SCALE 1:5

**WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 x 45°  
2) INSERT D2743 SPACER  
3) WELD INTO PLACE  
4) GRIND WELD FLUSH  
5) DRILL OUT SPACER TO Ø0.484  
6) SPOT FACE Ø0.750 (SECTION P-P ONLY)

**SECTION P-P**  
SCALE 1:5

INSTALL:  
AN6C44A BOLT (1)  
D2745 BUSHING (2)  
D3631-1 WASHER (2)  
MS21043-6 NUT (1)  
(4 PLACES)

**SECTION Q-Q**  
SCALE 1:5

INSTALL:  
AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

**SECTION R-R**  
SCALE 1:5

D3490-3 SPACER  
INSTALL:  
D3492-043 PLUG  
ASSEMBLY (2 PLACES)  
(TYP)

**SECTION K-K**  
(FOR Ø0.750 HOLES ONLY)  
SCALE 1:5

**WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 x 45°  
2) INSERT D3490-1 SPACER (4 PLACES) INTO  
Ø0.500 HOLES OR INSERT D3490-3 SPACER  
(4 PLACES) INTO Ø0.750 HOLES  
3) WELD INTO PLACE  
4) GRIND WELD FLUSH  
5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES)  
INTO D3490-1 SPACER OR INSERT D3492-043  
PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER  
ON BOTH ENDS AFTER FINISH

D3490-1 SPACER

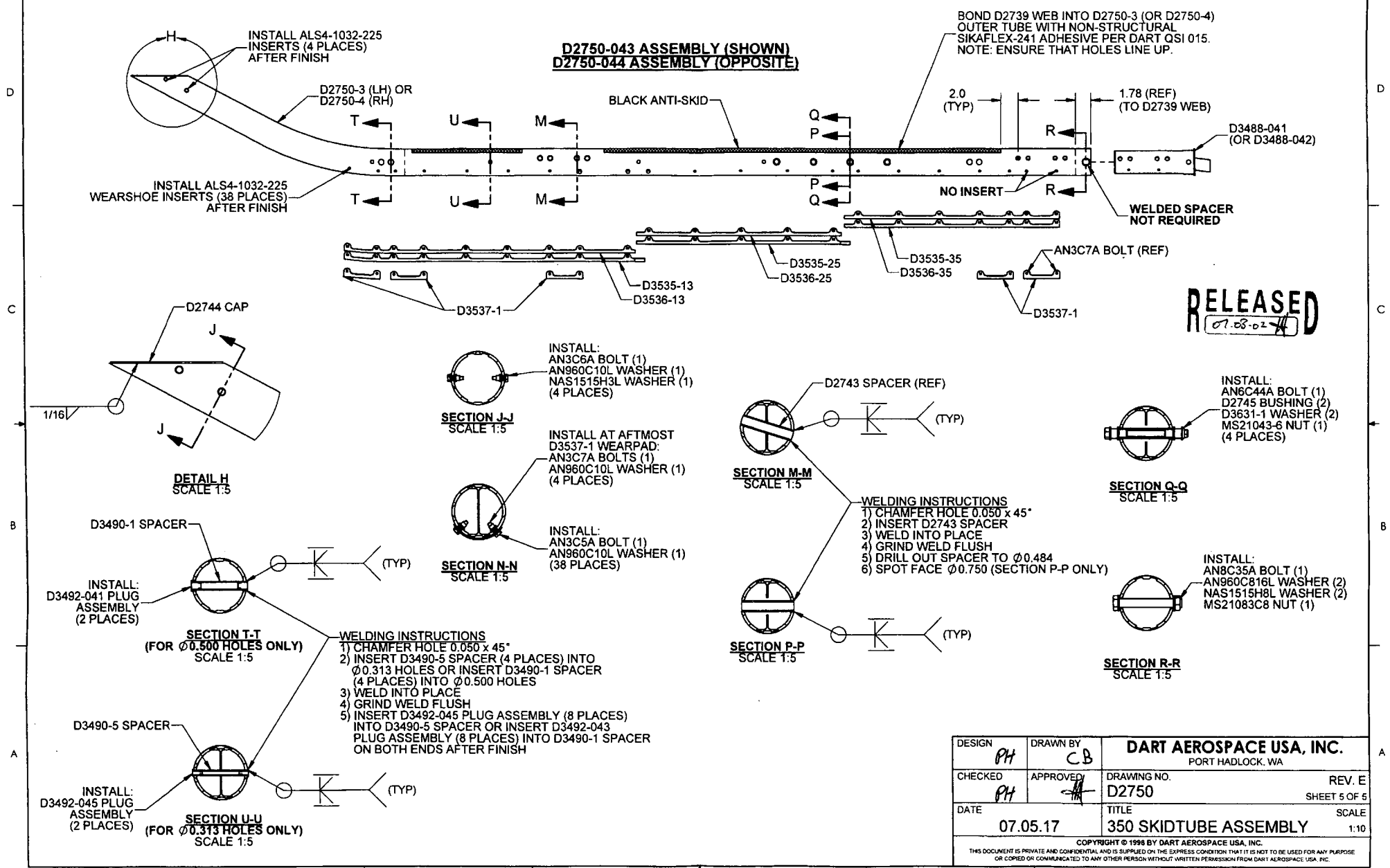
INSTALL:  
D3492-041 PLUG  
ASSEMBLY (2 PLACES)  
(TYP)

**SECTION L-L**  
(FOR Ø0.500 HOLES ONLY)  
SCALE 1:5

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CHECKED	PH	APPROVED	[Signature]	PORT HADLOCK, WA	
DATE	07.05.17	DRAWING NO.	D2750	REV. E	
		TITLE	350 SKIDTUBE ASSEMBLY	SHEET 4 OF 5	SCALE 1:10
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8 7 6 5 4 3 2 1



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07-08-02

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CHECKED PH	APPROVED [Signature]	DRAWING NO. D2750	REV. E SHEET 5 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10

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# DART

TEL.: 1-613-632-3336  
FAX: 1-613-632-4443

TRANSPORT CANADA APPROVAL # 09-89

P/N	D350-636-013	CHG	CHG002
DESC.	Skidtube Assembly	STC	SH99-7
LOT	B33392	STC	SR00646SE
MODEL	AS350/355	STC	

US PATENT # 5735181

MADE IN CANADA

CANADA FOREIGN PATENTS PENDING